

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024900**Date Inspected:** 30-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b> Yes No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b> Yes No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b> Yes No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b> Yes No N/A
				<b>Delayed / Cancelled:</b> Yes No N/A

**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

DCP:

Traveler Rails

This Quality Assurance (QA) Inspector witnessed final tension verification for Traveler Rails. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00676 Dated June 29, 2011.

25TR1-001 &amp; 25TR1-002

Bolt sizes used were M16 x 80 DHGM160013 and final torque required was 193 N-m.

28TR1-002

Bolt sizes used were M16 x 80 DHGM160013 and final torque required was 193 N-m.

30TR1-001 &amp; 30TR1-002

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Bolt sizes used were M16 x 80 DHGM160013 and final torque required was 193 N-m.

32TR1-001 & 30TR1-002

Bolt sizes used were M16 x 80 DHGM160013 and final torque required was 193 N-m.

33TR1-001

Bolt sizes used were M16 x 80 DHGM160013 and final torque required was 193 N-m.

34TR1-001

Bolt sizes used were M16 x 80 DHGM160013 and final torque required was 193 N-m.

35TR1-001

Bolt sizes used were M16 x 80 DHGM160013 and final torque required was 193 N-m

Manual Torque wrench was been used with Sr. No. XQ2-114.

BLAST SHOP 2,

Segment 14West

This QA Inspector performed Blast inspection on base metal, fillet welds and complete joint penetration (CJP) welds from panel point (PP) 125 to PP128 on external surface of vertical plate, side panel, edge panel and bottom panel of OBG segment 14West on at cable side. During inspection, several non conforming discontinuities such as weld spatter, deep gouges and arc strikes were observed. At Various locations these areas were marked up for repair. All information regarding this marked on weld map and submitted to Lead QA Inspector.

BLAST SHOP 1

Segment 14East

This QA Inspector performed Blast inspection on base metal, fillet welds and complete joint penetration (CJP) welds from panel point (PP) 127.5 to PP128.7 on external surface of vertical plate, Edge Plate, Floor Beam, I-Rib stiffener, side panel, edge panel and bottom panel of OBG segment 14East. During inspection, several non conforming discontinuities such as weld spatter, deep gouges and arc strikes were observed. At Various locations these areas were marked up for repair. All information regarding this marked on weld map and submitted to Lead QA Inspector.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey - 15000026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Prabhune,Manoj

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer